

Customer	:	CU-DAR001 Dart Helicopters Services	Drawing Name	:	DOUBLER
Job Number	:	32865			
Estimate Number	:	10709			
P.O. Number	:	N/A	Part Number	:	D32101
This Issue	:	6/7/2007	S.O. No.	:	N/A
Prsht Rev.	:	NC	Drawing Number	:	D3210 REV A
First Issue	:	N/A	Project Number	:	N/A
Previous Run	:	31427	Drawing Revision	:	A
		Type :	Material	:	N/A
		MACHINED PARTS	Due Date	:	6/26/2007
Written By	:	<u>[Signature]</u>	Qty:		10 Um: Each
Checked & Approved By	:	<u>[Signature]</u>			
Comment	:	Est Rev:A New Issue 05-11-17 JLM			
		Est Rev:B Now On Waterjet 06-10-24 JLM			

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
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1.0 M2024T3S080 2024-T3 .080 sheet

Comment: Qty.: 2.6177 sf(s)/Unit Total : 26.1765 sf(s)
Material: 2024-T3 (QQ-A-250/4) 0.080" thick
(M2024T3S.080) Identify as D3210-1
Batch: M104469

20 WATER JET FLOW WATER JET

Comment: FLOW WATER JET
1-Cut as per Dwg D3210
Dwg Rev: A
Prog Rev: A

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

40 QC8 SECOND CHECK

Comment: SECOND CHECK

50	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/29

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 32865

Part Number: D32101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

LD

07-06-27

X10

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

BK/M

07-06-28

10

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/06/29 @

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 268

07/06/29 @

10

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/29

Job Completion



07-06-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

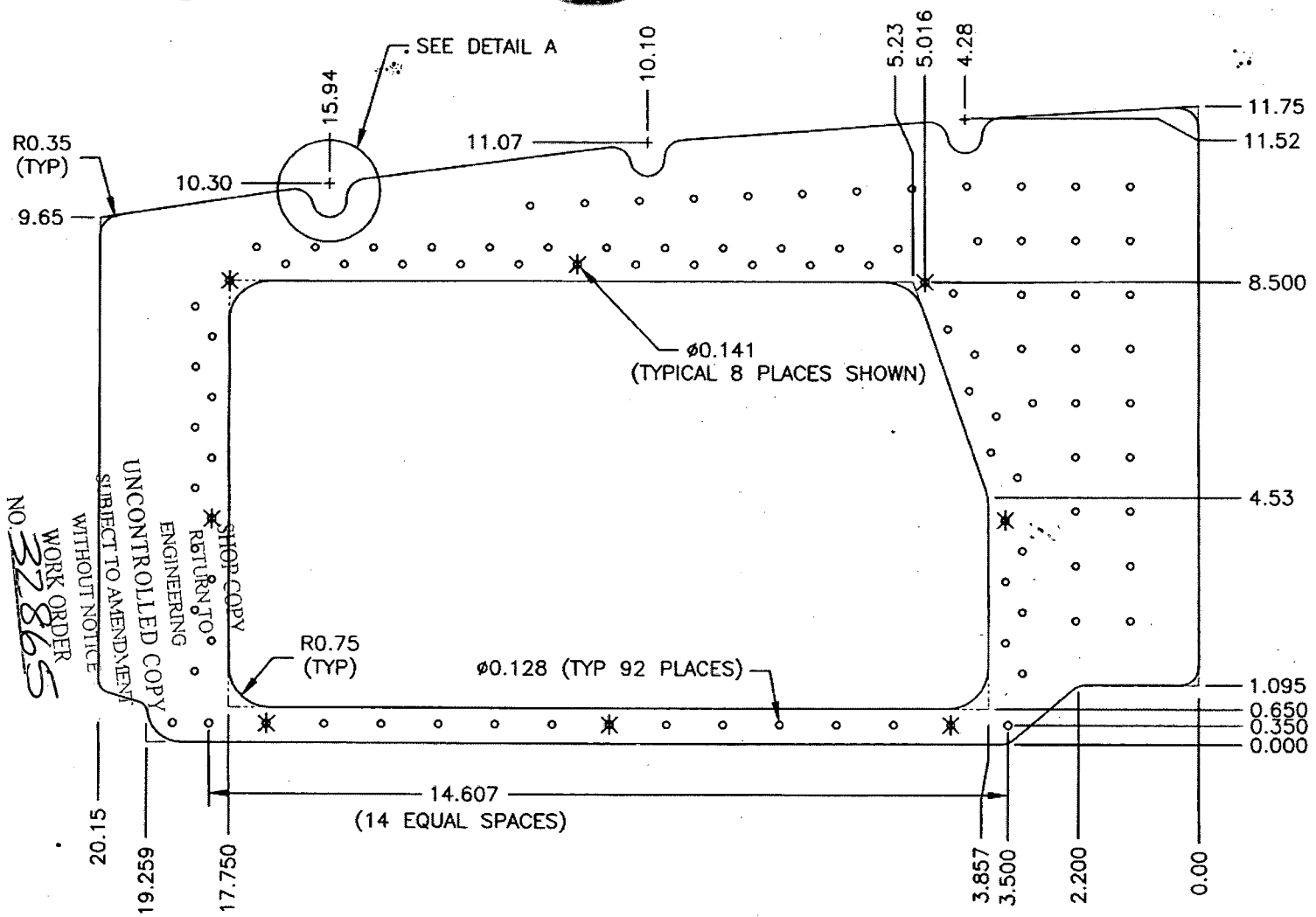
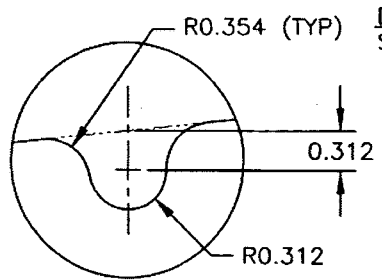


DESIGN	W	DRAWN BY	W	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED		APPROVED		DRAWING NO. D3210
DATE	03.09.03	TITLE	DOUBLER	REV. A
				SHEET 1 OF 1
				SCALE 1:3
A	03.09.03	NEW ISSUE		

D3210-1 DOUBLER
MAKE PER DRAWING FILE "D3210-A1.DWG"
CHECK PER TEMPLATE D3210-1T1
DIMENSIONS SHOWN FOR REFERENCE ONLY
MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER
DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
03.09.03

DETAIL A
SCALE 2:3



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DART AEROSPACE LTD		Work Order: 32865
Description: Doubler		Part Number: D3210-5
Inspection Dwg: D3210 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A $\phi 0.141$	$+0.005$ -0.000	0.141	✓		VEN	
B $\phi 0.128$	$+0.005$ -0.000	0.128	✓		VEN	
C 3.851	$+1-0.010$	3.866	✓		VEN	
D 17.750	$+1-0.010$	17.750	✓		M.T	
E 20.15	$+1-0.030$	20.15	✓		M.T	
F 8.500	$+1-0.010$	8.500	✓		M.T	
G 1.095	$+1-0.010$	1.000	✓		H-G	
H 0.650	$+1-0.010$	0.659	✓		VEN	
I 0.350	$+1-0.010$	0.351	✓		VEN	
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: ml. ml	Audited by: En	Prototype Approval:	N/A
Date: 07 06 17	Date: 07/06/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	